

Work Order ID 156232 - 2

156232

Page 1

Friday, January 27, 2017 12:49:09 PM

Item ID: D350-567-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Floor Window Close Out

Stop

NS2

Start Date: 1/17/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/27/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS

Date:

JAN 31 2017

Tooling:

Date:

Run

Start

NR1

QC:

DAS

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9590

F

FEB 09 2017

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-567-141 CHG004

DAS
21
9-89

FEB 24 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

FEB 09 2017

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.01

Quality Control

DAS
28
9-89

FEB 24 2017

DAS
26
9-89

Work Order ID 156232

156232

Page 2

Friday, January 27, 2017 12:49:09 PM

Item ID: D350-567-141

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Floor Window Close Out

Stop *NS2*

Start Date: 1/17/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/27/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					1	DAS 28 9-89	FEB 24 2017	
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-141 Location:FG033								
140	QC21- Final Inspection - Work Order Release	0.00							
140								FEB 24 2017	
QC	Memo	0.03							
Quality Control									

FEB 23 2017

Picklist Print

Friday, January 27, 2017 12:49:08 PM

Page 1

Work Order ID: 156232

156232

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 1/17/2017

Required Date: 1/27/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B
12.01.23 AS PER ECN12-511 DD VERF:EC IPP REV:C 12.03.05
AS PER ECN12-537 DD VERF:EC IPP REV:D 13.04.01 AS PER
DSI9590 REV.E DD VERF:JLM IPP REV :E AS PER DSI9590 REV F JLM
VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4434-047

Manufactured

No

Each

2.0000

2

D4434-047

Cover Assembly

**

FEB 10 2017

DAS
6
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST619

2

152288

2

153129

D3802-1

Manufactured

No

110

f

22.3158

2

4

D3802-1

Window Seal (\$ per foot)

**

FEB 10 2017

DAS
6
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST416

22.31578947

153922

22.3157895

147067

D4434-041

Manufactured

No

110

Each

0.0000

1

2

D4434-041

Fwd Bracket Assembly

**

FEB 10 2017

DAS
6
9-89

DAS
26
9-89

D4435-045

Manufactured

No

110

Each

1.0000

1

2

D4435-045

T/R Bellcrank Cover Assembly

**

FEB 10 2017

DAS
6
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST620

1

152205

1

153097

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

Picklist Print

Friday, January 27, 2017 12:49:08 PM

Page 2

Work Order ID: 156232

156232

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 1/17/2017

Required Date: 1/27/2017

Start Qty: 2.00

Required Qty: 2.00

D4435-9 Manufactured No

110 Each 10.0000

D4435-9

Bracket

**

2 4

DAS
28
9-89

Location

Loc Qty

Loc Code

ST098

10

155788

10

D4436-041 Manufactured No

110 Each 0.0000

D4436-041

Aft Bracket Assembly

**

1 2

DAS
28
9-89

D4441-1 Manufactured No

110 f 433.3140

D4441-1

Rubber Seal

**

2 4

DAS
28
9-89

Location

Loc Qty

Loc Code

ST422

183.314

151347

183.314

ST625

250

151347

250

AN3-3A Purchased No

110 Each 195.0000

AN3-3A

Bolt

**

7 14

DAS
28
9-89

Location

Loc Qty

Loc Code

ST350

195

m136199

95

m136643

100

AN525-10R6 Purchased No

110 Each 236.0000

AN525-10R6

Screw

**

2 4

DAS
28
9-89

Location

Loc Qty

Loc Code

ST329

236

M134502

236

Friday, January 27, 2017 12:49:08 PM

Shop Packet Print

Page 2

Picklist Print

Friday, January 27, 2017 12:49:08 PM

Work Order ID: 156232

156232

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 1/17/2017

Required Date: 1/27/2017

Start Qty: 2.00

Required Qty: 2.00

AN525-832R7

Purchased

No

110

Each

97.0000

2

4

**

DAS
6
9-89

DAS
26
9-89

FEB 10 2017

AN525-832R7

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

83

m136147

83

ST328

14

m134070

14

110

Each

161.0000

7

14

**

DAS
6
9-89

FEB 10 2017

DAS
26
9-89

MS21042L06

Purchased

No

MS21042L06

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST303

161

m136199

18

m136301

43

m136643

100

110

Each

844.0000

2

4

**

DAS
6
9-89

FEB 10 2017

DAS
26
9-89

MS21042L08

Purchased

No

MS21042L08

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

503

m135274

18

m135978

485

ST303

341

m136301

174

m136537

7

m136643

160

Picklist Print

Friday, January 27, 2017 12:49:08 PM

Page 4

Work Order ID: 156232

156232

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 1/17/2017

Required Date: 1/27/2017

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

110

Each

1,988.000

5

10

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

158

m134360

108

m135135

50

OVER007

1000

M136554

500

M136665

500

ST303

730

M136044

11

M136192

219

M136406

500

DAS
6
9-89

FEB 10 2017

DAS
28
9-89

MS21059L3

Purchased

No

110

Each

155.0000

2

4

MS21059L3

Nut Plate

**

Location

Loc Qty

Loc Code

GA

63

M136047

63

ST301

92

M135774

27

M136450

65

DAS
6
9-89

FEB 10 2017

DAS
28
9-89

MS35206-229

Purchased

No

110

Each

305.0000

7

14

MS35206-229

Screw

**

Location

Loc Qty

Loc Code

ST271

305

M135603

305

DAS
6
9-89

FEB 10 2017

DAS
28
9-89

Friday, January 27, 2017 12:49:08 PM

Shop Packet Print

Page 4

Picklist Print

Friday, January 27, 2017 12:49:08 PM

Page 5

Work Order ID: 156232

156232

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 1/17/2017

Required Date: 1/27/2017

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0332P

Purchased

No

110

Each

2,044.000

12

24

NAS1149F0332P

Washer

**

DAS
6
9-89

FEB 09 2017

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

343

m133709

343

ST262

1701

m135948

5

m136442

1696

NAS1149FN616P

Purchased

No

110

Each

102.0000

14

28

NAS1149FN616P

WASHER

**

DAS
6
9-89

FEB 09 2017

DAS
26
9-89

Location

Loc Qty

Loc Code

ST264

102

M136199

102

NAS1149FN816P

Purchased

No

110

Each

394.0000

2

4

NAS1149FN816P

WASHER

**

DAS
6
9-89

FEB 09 2017

DAS
26
9-89

Location

Loc Qty

Loc Code

ST263

394

117316

394

DAS
28
9-89

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. E OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-18

FAA STC: SH989NE

FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141/-143/-145 Close-out Kits, which are intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141/-143/-145 Floor Window Close-out Kits provide a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1. The -143 Kit is identical to the -141 Kit with the exception of the D4971-041 T/R Bellcrank Cover Assy which replaces the D4435-045 T/R Bellcrank Cover Assy on aircraft fitted with energy attenuating seats. The -145 Kit is similar to the -143 Kit but is only kit compatible with the AS350 B3e aircraft.

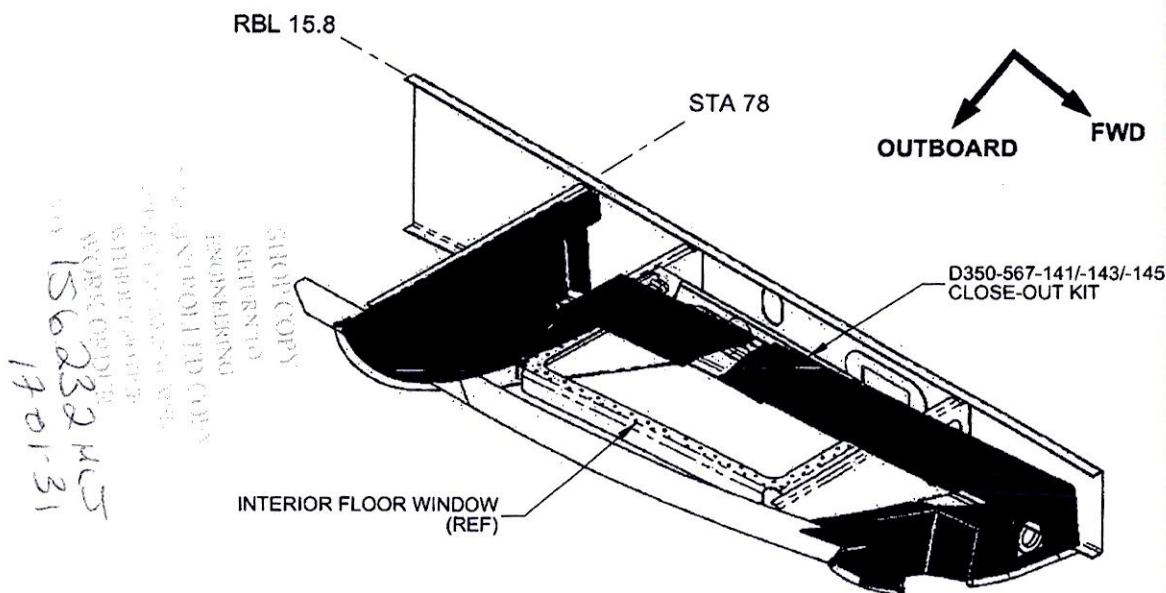


Figure 1. Floor Window Close-out Kit Installation

F	ADDED D4434-047 TO -141 KIT SEE PAR14-372.	AJS	15.01.12
E	ADD -143/-145 KITS	RF	14.03.20
E	CLARIFY FIGURES 3-12	VS	13.09.11
C	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P	RF	12.03.13
B	MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

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DEPARTMENT OF TRANSPORT
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BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
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ISSUE NO.: 6

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

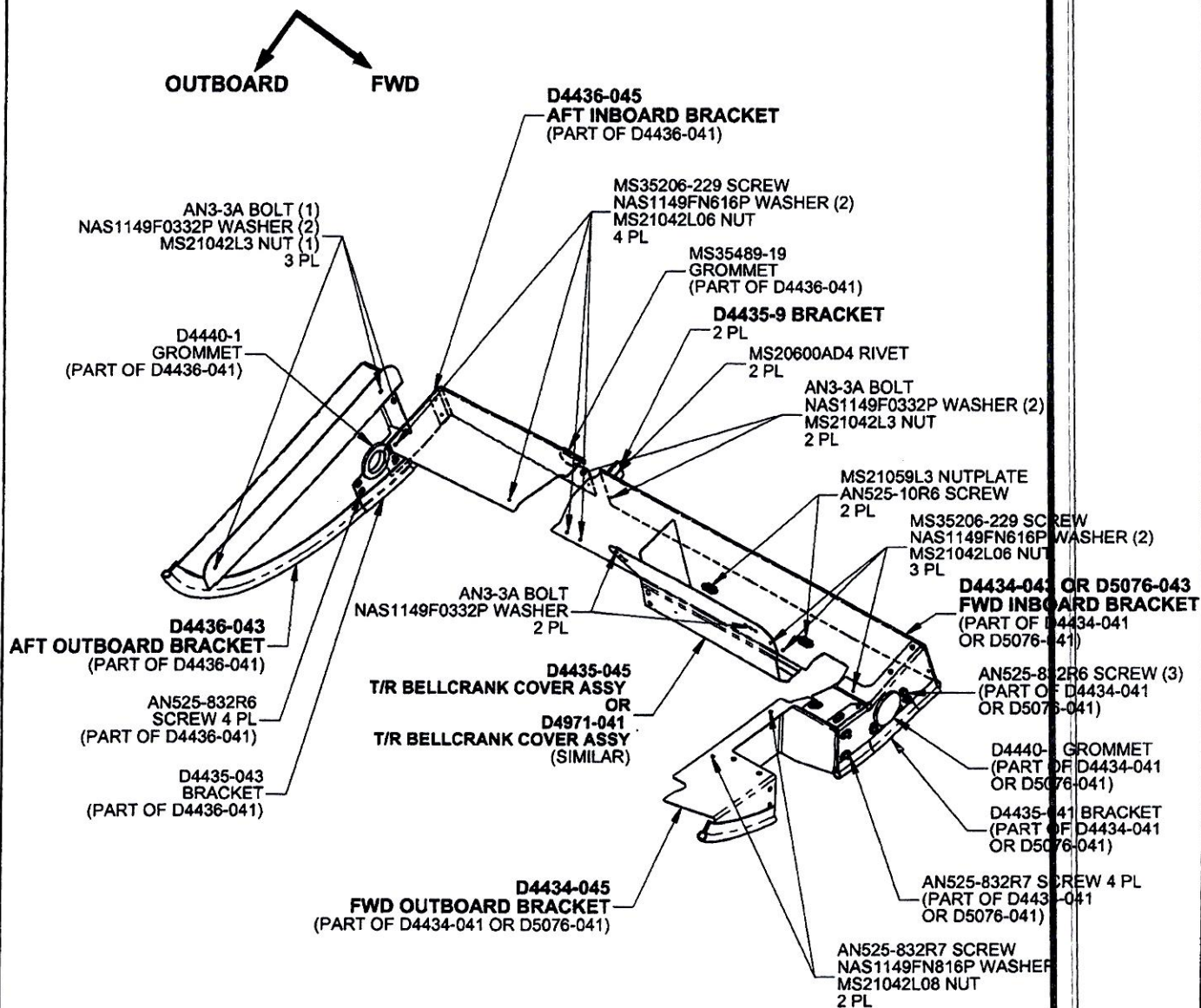


Figure 2. Floor Window Close-out Kit Installation

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	NA	DSI 9590	SHEET 3 OF 19
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4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or cleco clamps. Before drilling holes:

- a) Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
- b) Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.

4.2 Temporarily install D4434-043/D5076-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 /D5076-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.

 4.3 For -141 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.4 For -143 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4971-041 T/R Bellcrank cover as shown in Figure 13b. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.5 For -145 installations, if aircraft is equipped with Collective Circuit Breaker Board box, use D5076-043 Fwd Inboard Bracket as shown in Figure 13c. Install D4971-041 T/R Bellcrank cover as shown in Figure 13c. Note: Confirm the D5076-3 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.6 Drill out rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x $\varnothing 0.144$ holes to D4434-043/D5076-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x $\varnothing 0.144$ holes for D4434-043/D5076-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043/D5076-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.

4.7 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.

4.8 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x $\varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.

4.9 Drill a pilot hole from D4435-9 Bracket to the D4434-043/D5076-043 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.

4.10 Transfer drill 2 x $\varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x $\varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 screws, NAS1149FN816P washer and MS21042L08 nuts.

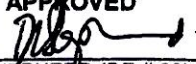
4.11 FOR D350-567-141 KIT

a) Align D4435-045 T/R Bellcrank Cover Assy with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12a.

b) Transfer drill 2 x $\varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover Assy to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12a and Figure 13a. Install D4435-045 T/R Bellcrank Cover Assy using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12a and Figure 13a.

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AIRCRAFT CERTIFICATION
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DAO # 01-O-01

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BY: 
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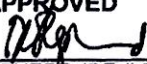
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DRAWN	AJS		
CHECKED		DRAWING NO. DSI 9590	REV. F
MFG. APPR.	N/A		SHEET 4 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
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4.12 FOR D350-567-143/-145 KIT

- a) Remove the D4972-041 Side Plate Assy from the D4971-041 T/R Bellcrank Cover Assy and retain fasteners.
 - b) Align D4971-1 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12b.
 - c) Bond D4730-020-030 Velcro to back of D4971-1 T/R Bellcrank Cover as shown in Figure 12b using CE 200 adhesive.
 - d) Transfer drill 2 x $\varnothing 0.098$ holes from D4971-1 Cover Plate to D4434-043/D5076-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043/D5076-043 Fwd Inboard Bracket as shown in Figure 13b/13c. Install D4971-1 Cover Plate using AN525-10R6 screws and D4730-020-030 Velcro per Figure 12b and Figure 13b/13c.
 - e) Re-install the D4972-041 Side Plate Assy using the retained fasteners.
- 4.13 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.14 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.15 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.16 Ensure there is a gap between the components of the D350-567-141/-143/-145 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-141 /-143/-145 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.

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BRANCH
DAO # 01-O-01

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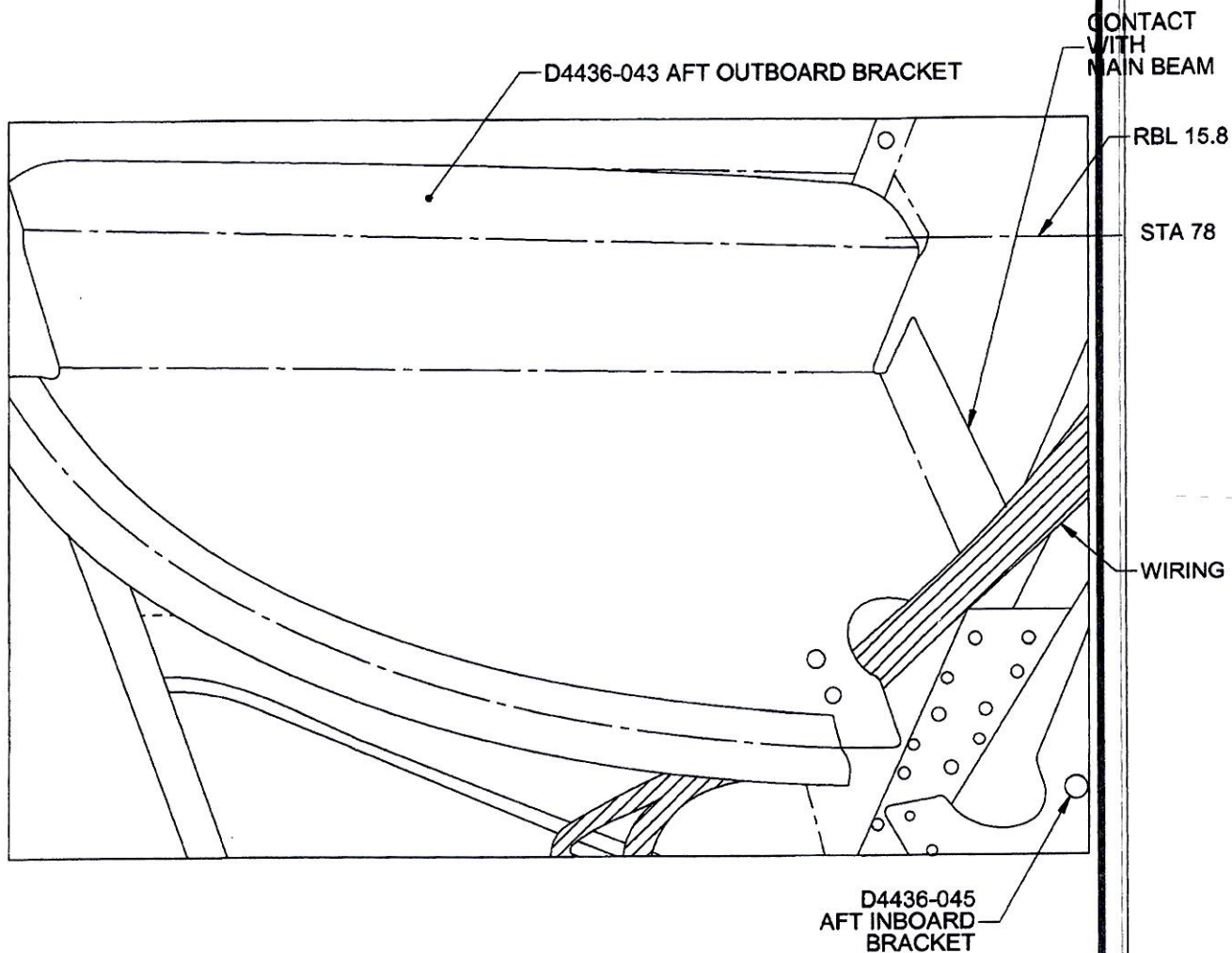


Figure 3. D4436-043 Aft Outboard Bracket Installation

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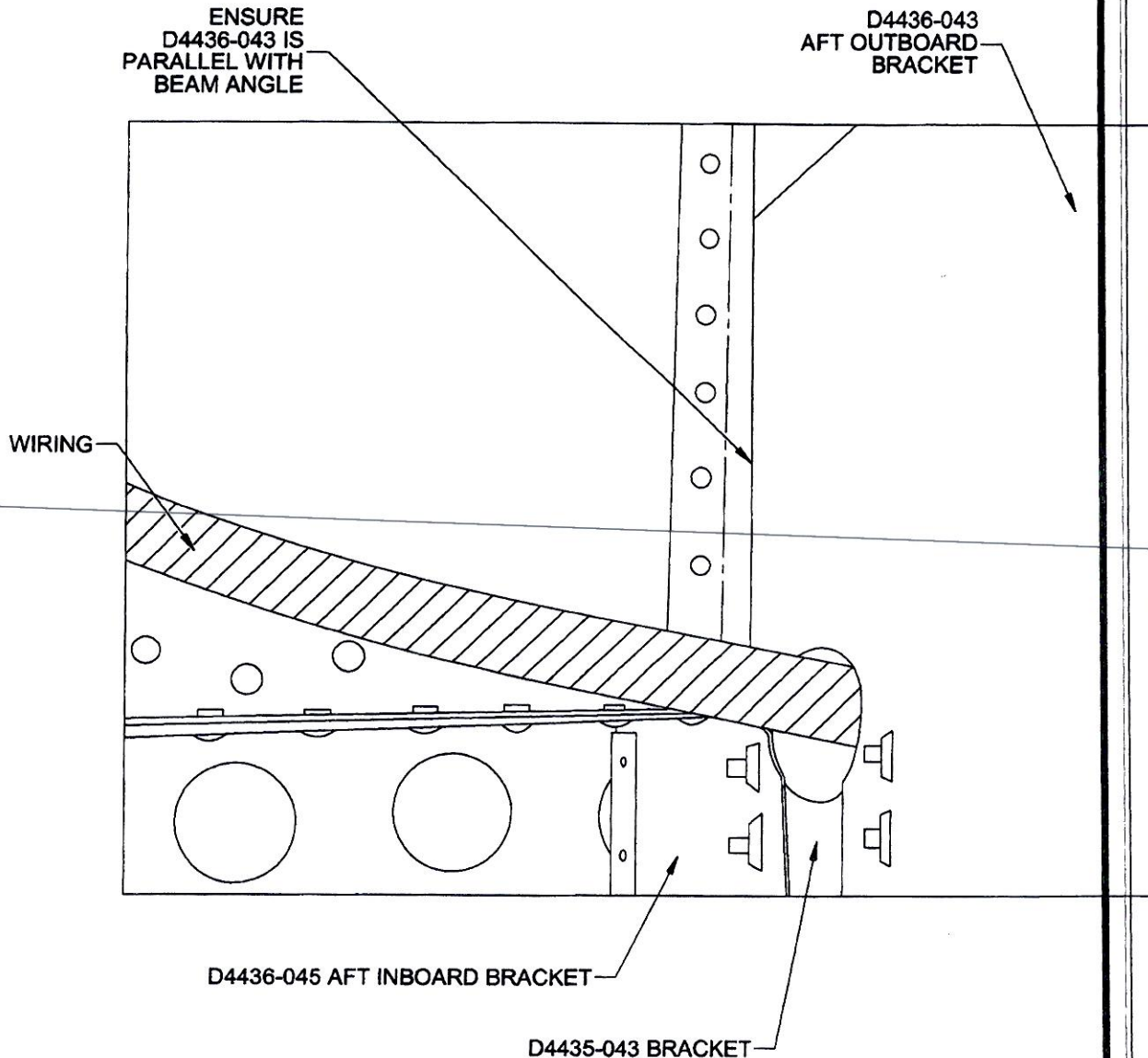


Figure 4. D4436-043 & D4435-043 Brackets Installation

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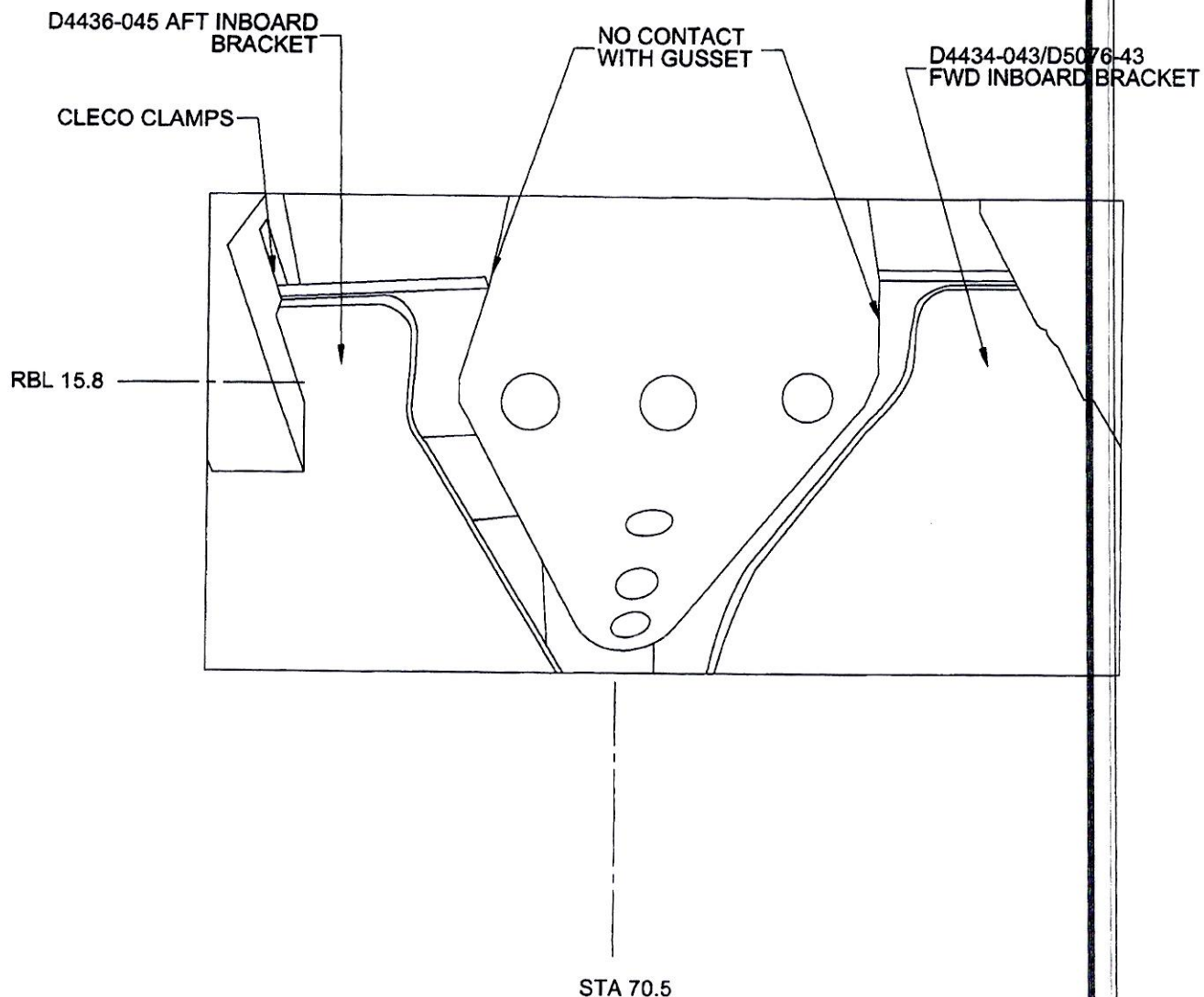


Figure 5. D4436-045 & D4434-043/D5076-043 Brackets Installation

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D4436-043
AFT OUTBOARD
BRACKET

CONFIRM
FLUSH WITH
OUTBOARD
EDGE OF MAIN
BEAM FLANGE

WIRING

PLASTIC STAND OFF
REF

RIVET HOLE
FOR PLASTIC
STAND OFF

CLECO CLAMPS

D4436-045
AFT INBOARD
BRACKET

Figure 6. D4436-043 & D4436-045 Brackets Installation

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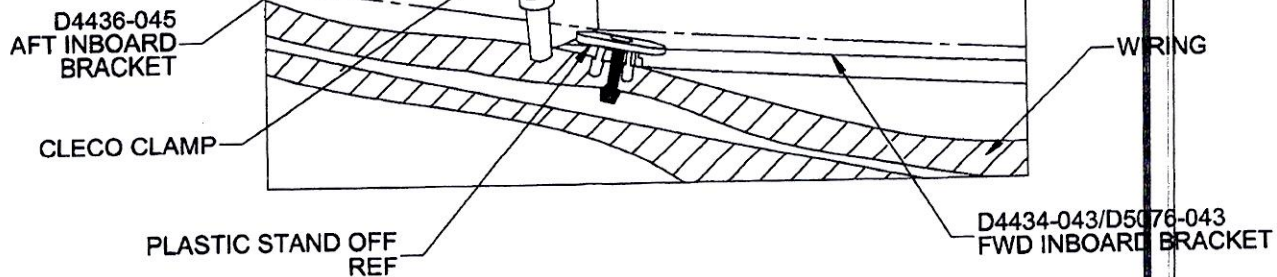


Figure 7. D4434-043/D5076-043 & D4436-045 Brackets Installation

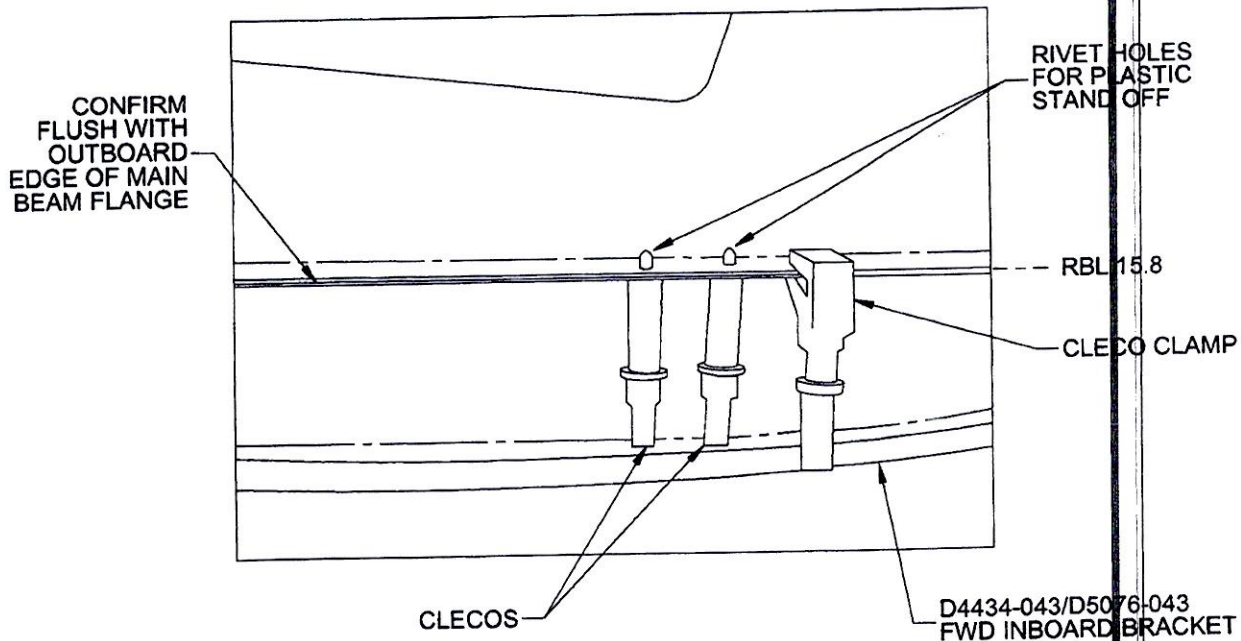


Figure 8. D4434-043/D5076-043 Fwd Inboard Bracket Installation

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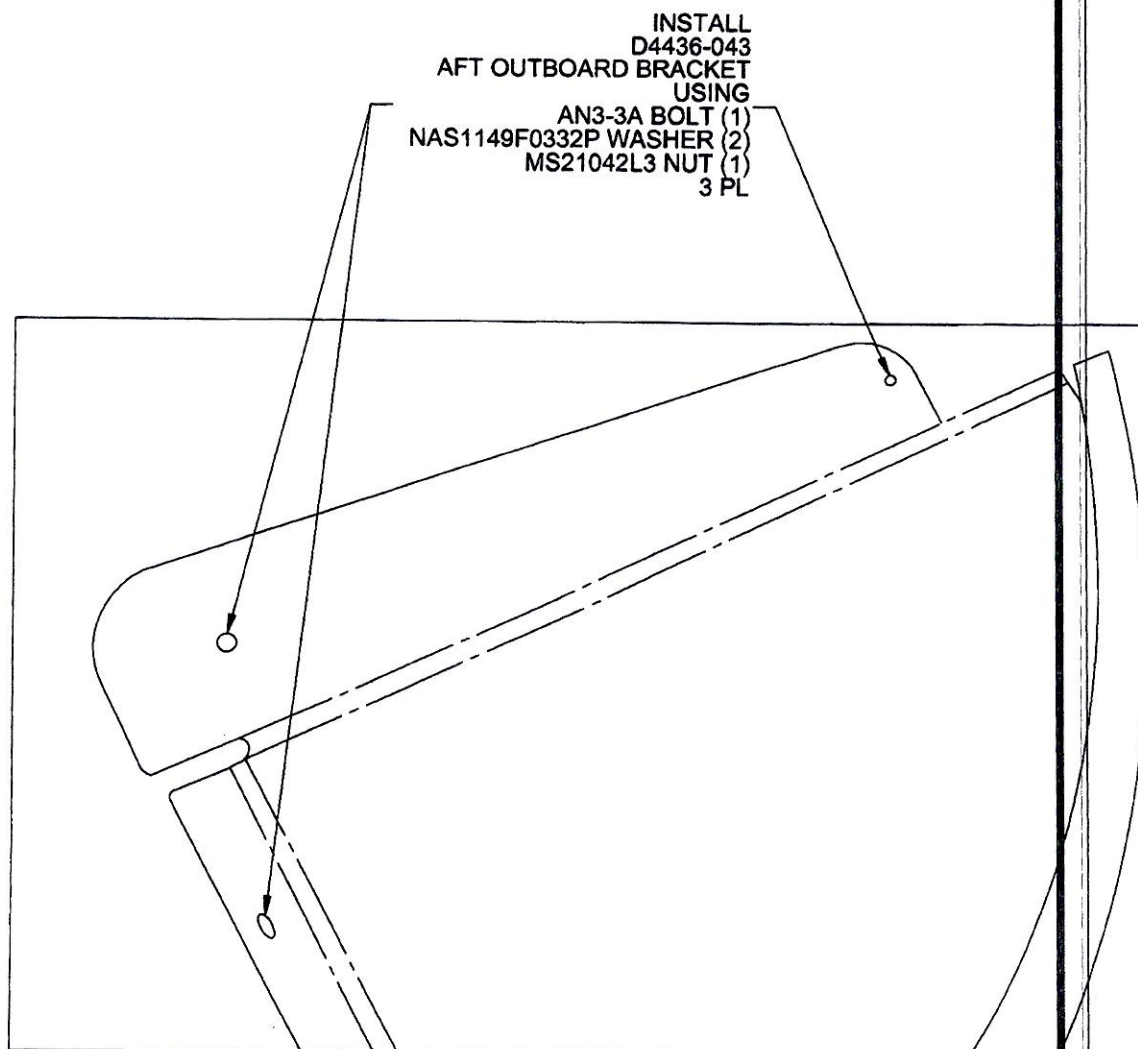


Figure 9. D4436-043 Aft Outboard Bracket Installation

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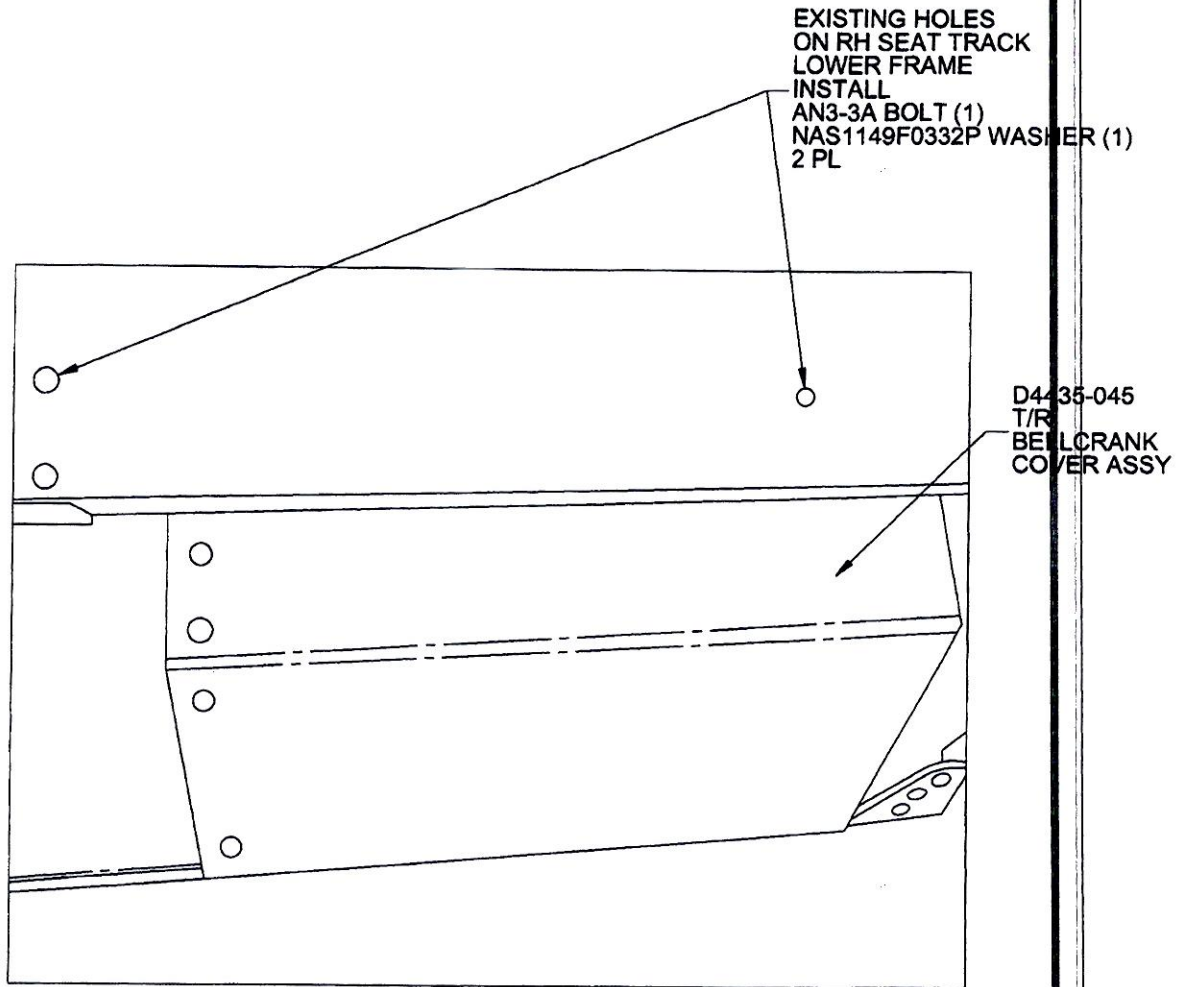


Figure 12a. D4435-045 T/R Bellcrank Cover Installation (-141)

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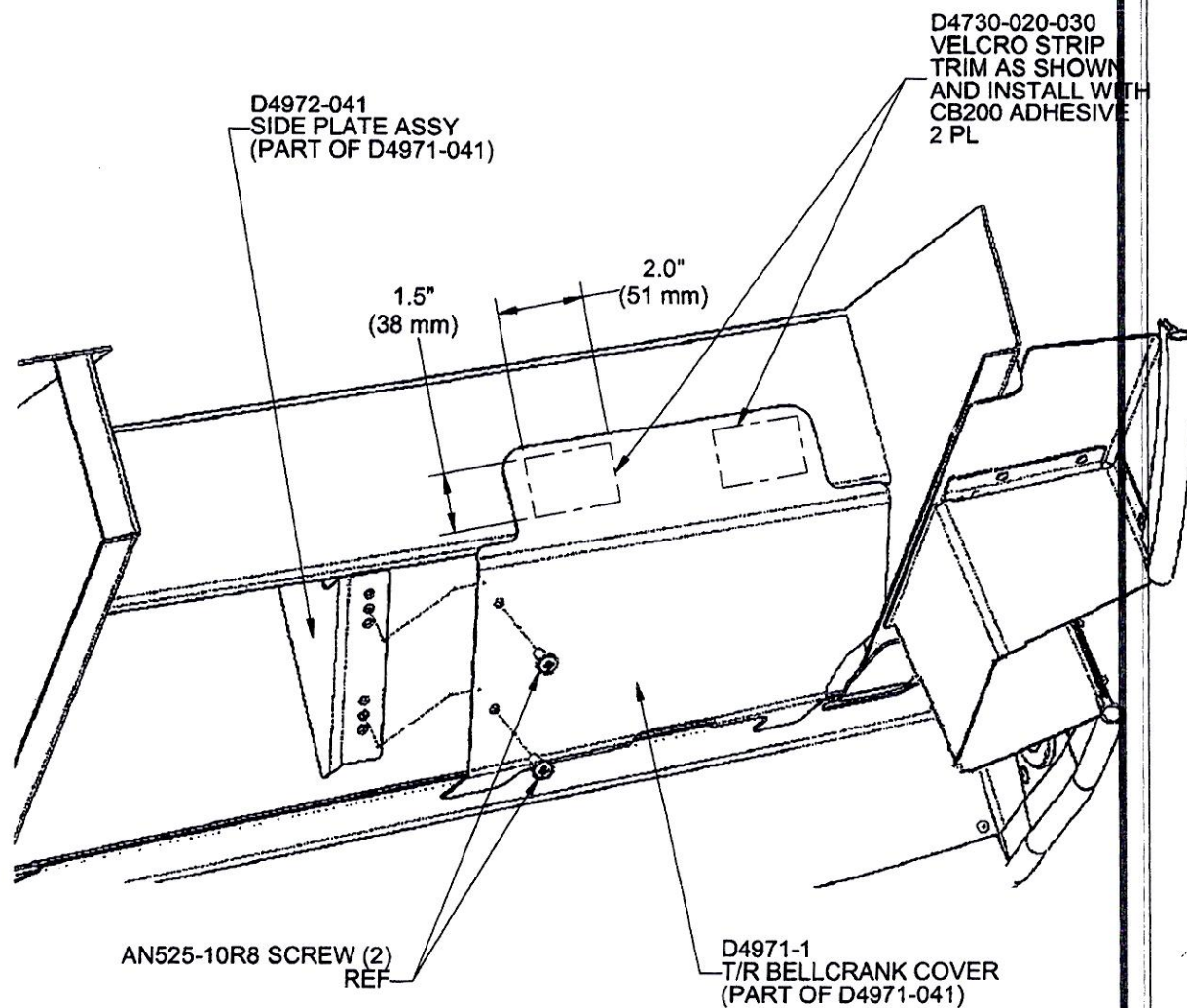


Figure 12b. D4971-041 T/R Bellcrank Cover Assy Installation (-143/-145)

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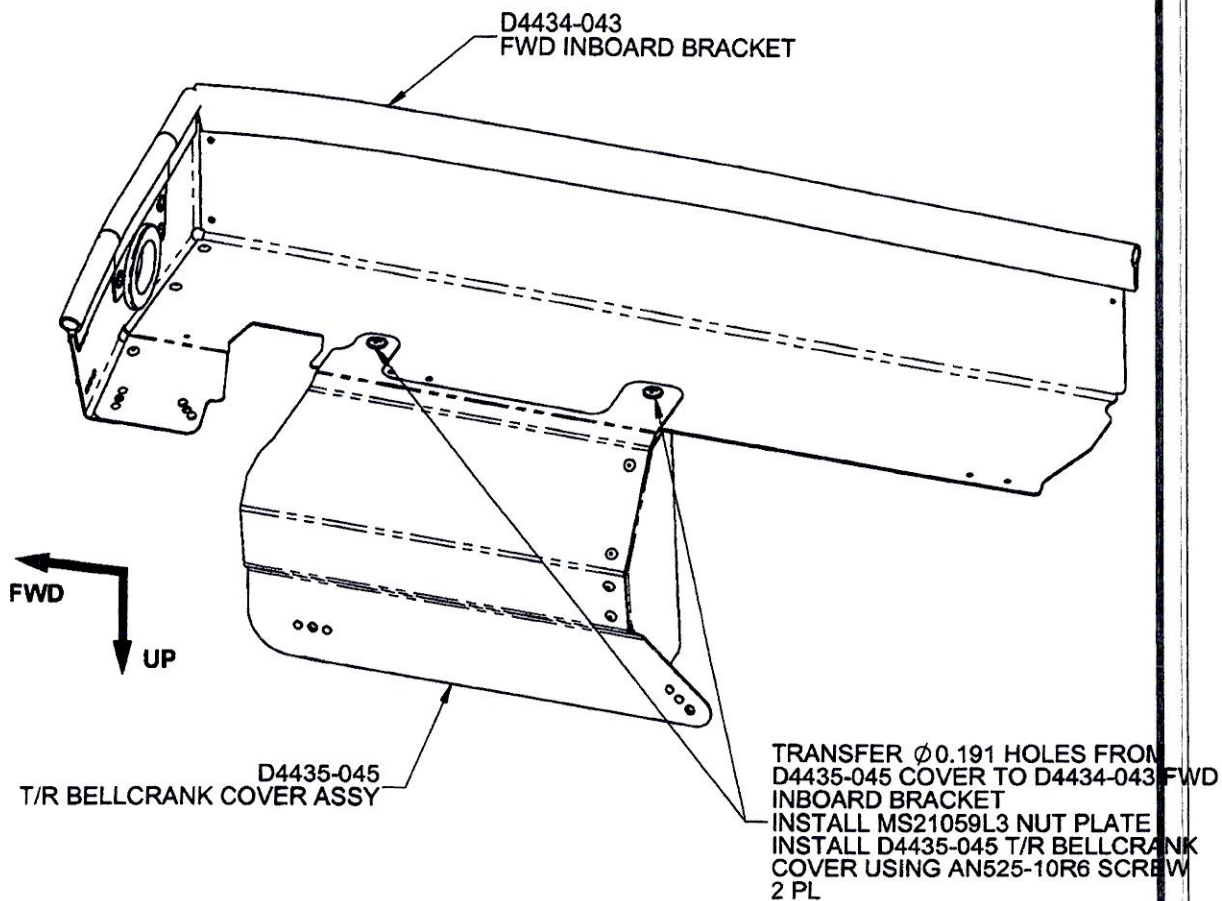


Figure 13a. D4435-045 Cover Installation (-141 ONLY)

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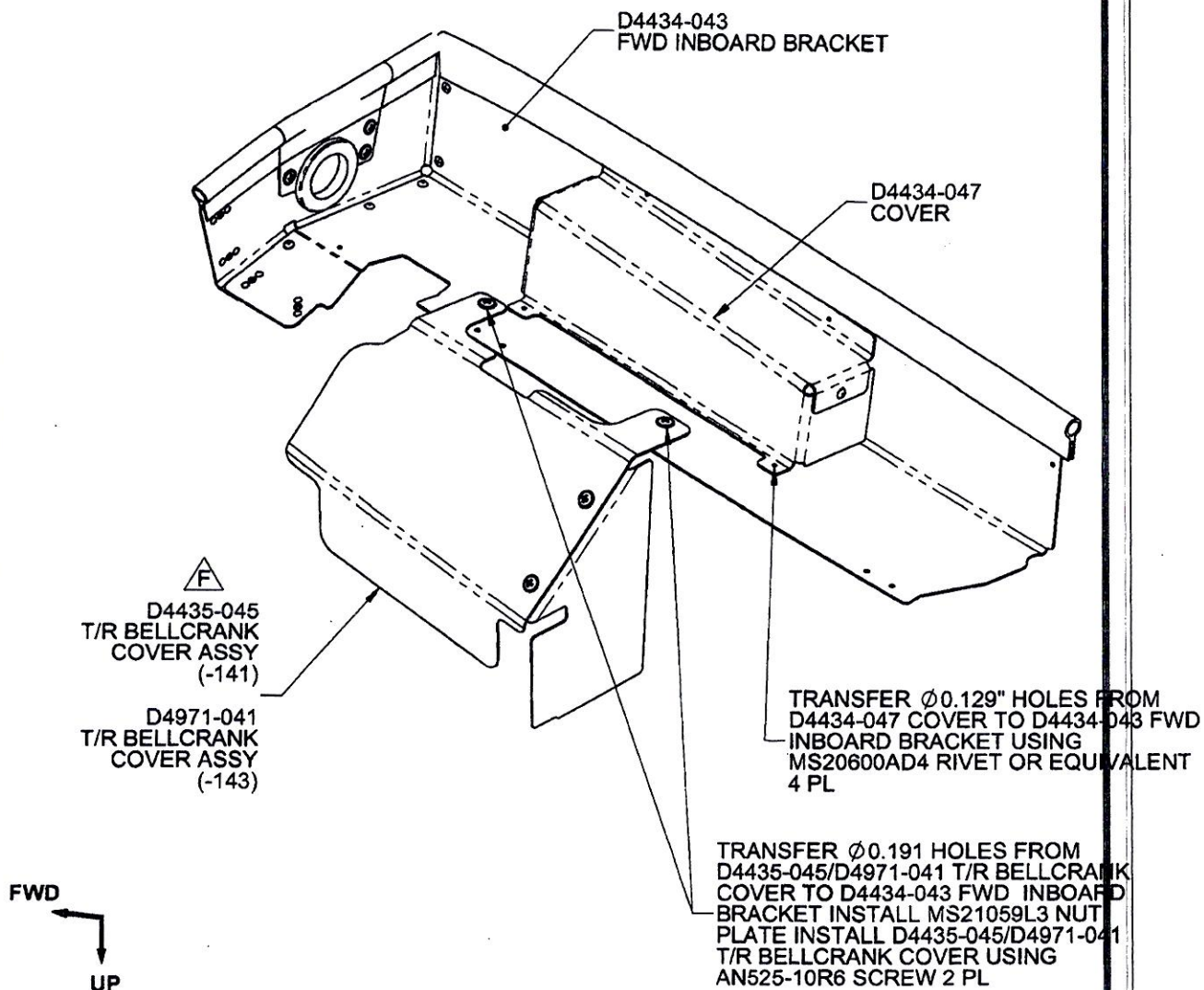


Figure 13b. D4971-041/D4435-045 & D4434-047 Cover Installation **F**
(D4434-047 is Optional on -141)

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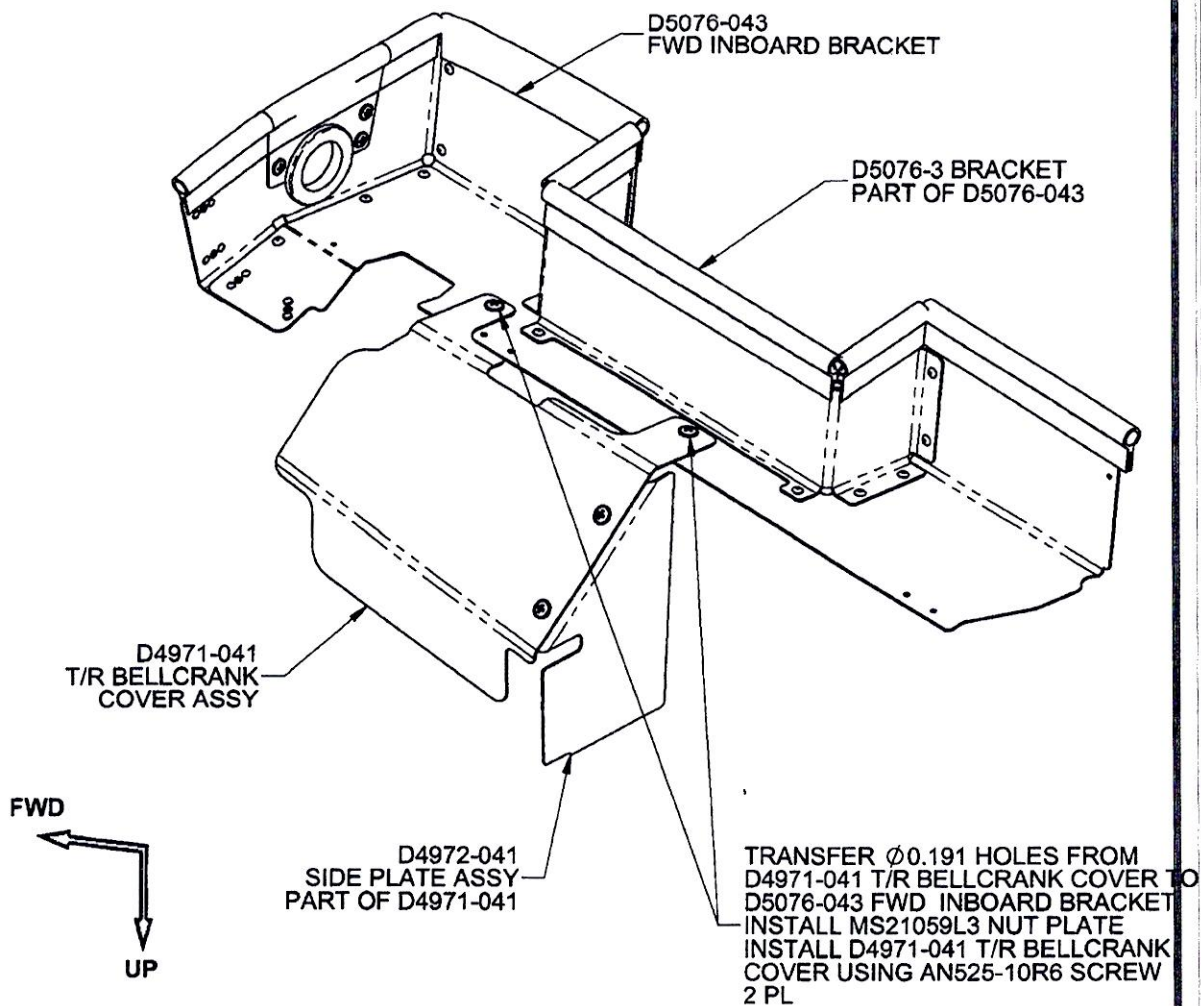


Figure 13c. D4971-041 INSTALLATION INTO D5076-043 (-145 ONLY)

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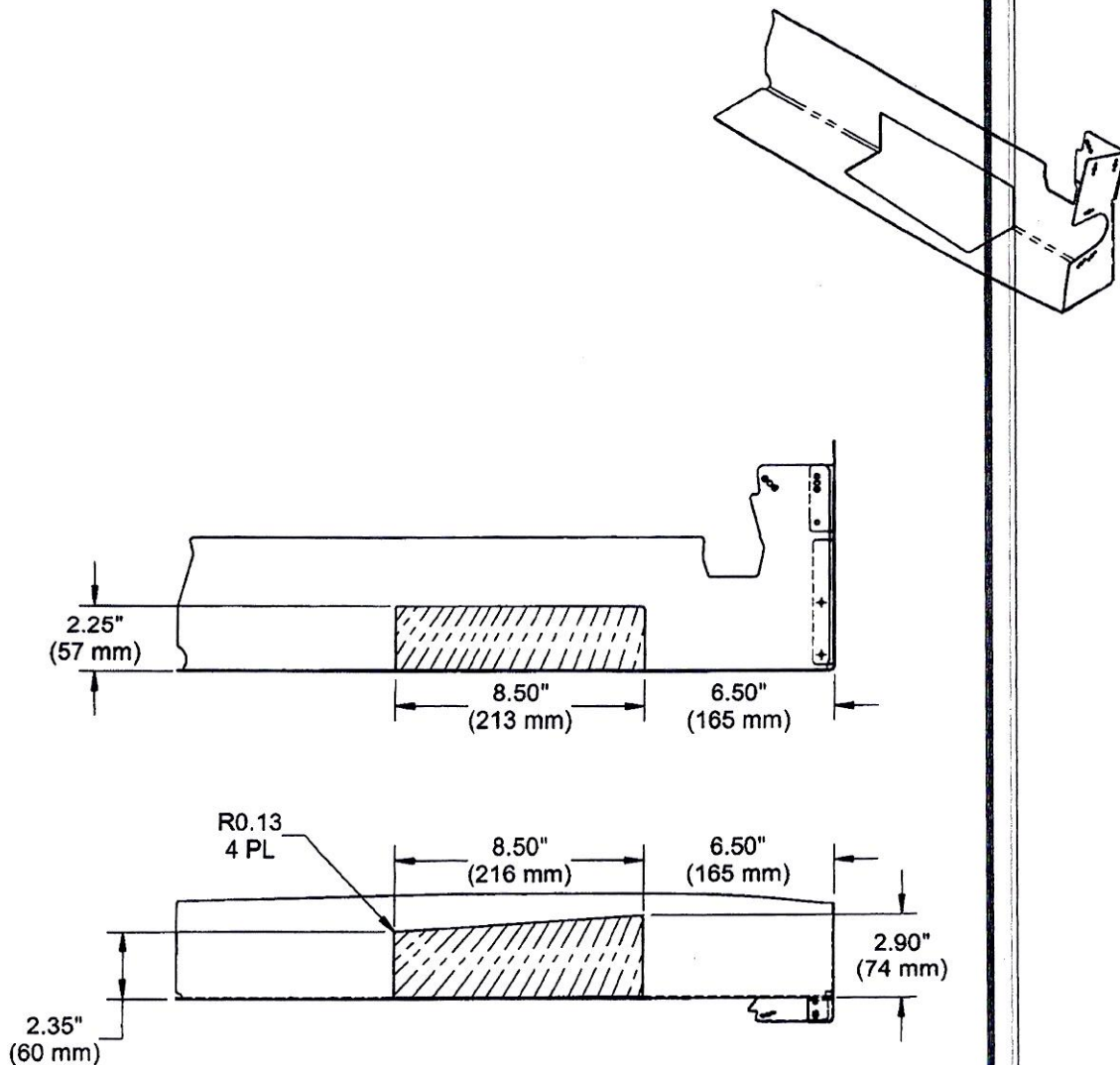


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

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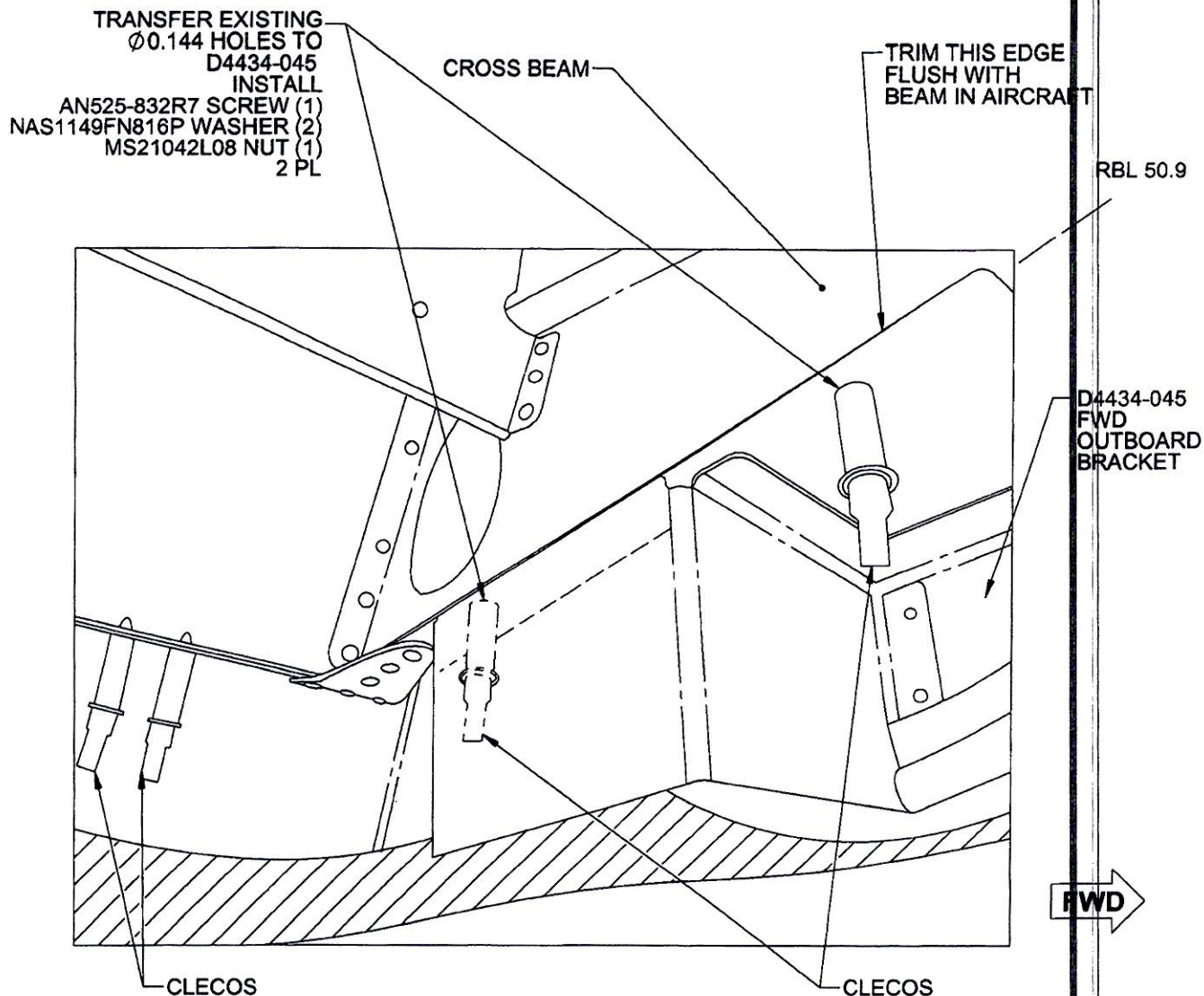


Figure 11. D4434-045 Bracket Installation

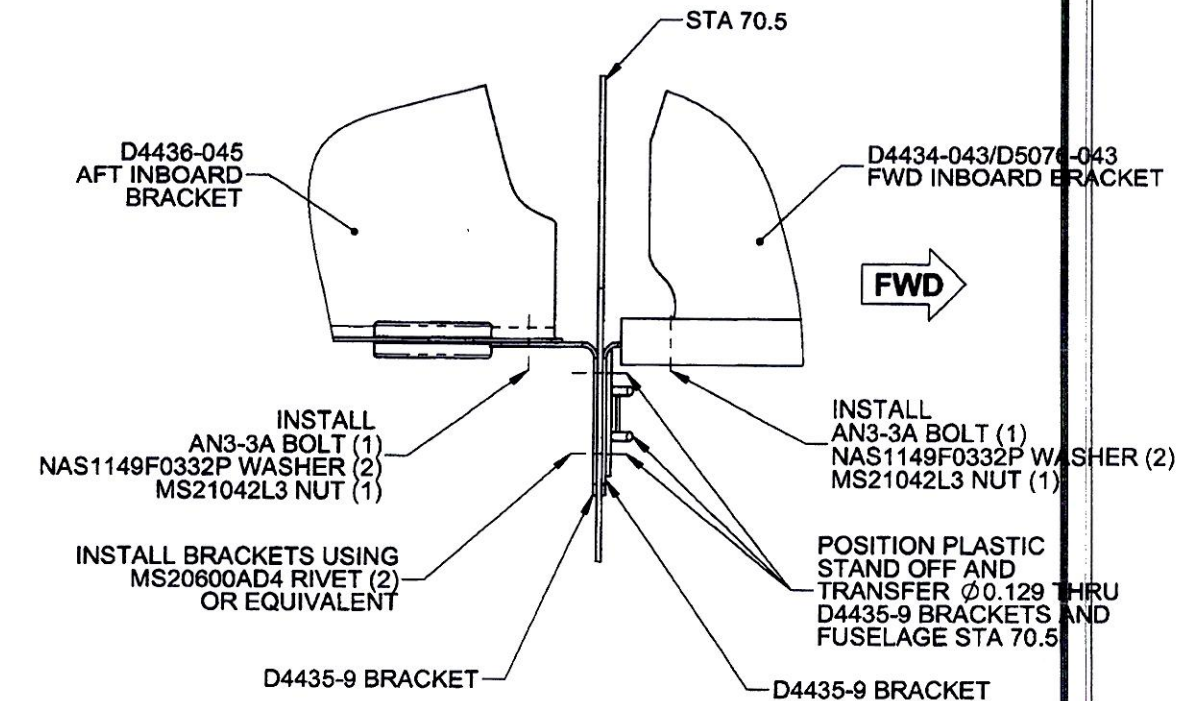
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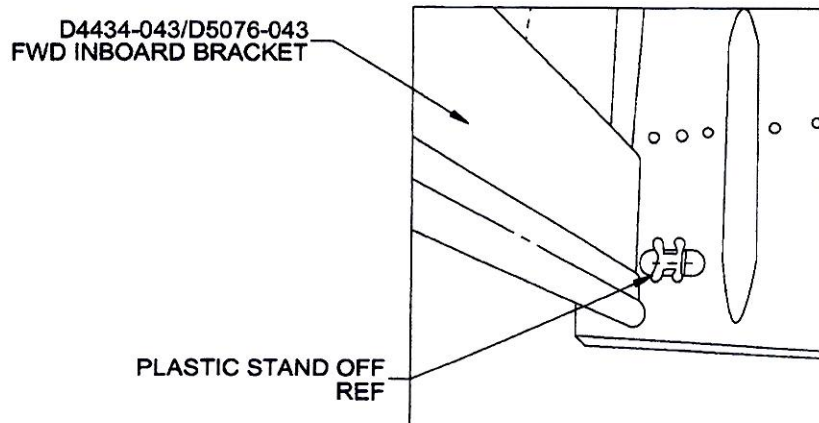


Figure 10. D4434-043/D5076-043 and D4435-9 Brackets Installation

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2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145 Floor Window Close-out Kit	3.9 lb 1.77 kg	17.9 in 0.45 m	69.8 in-lb 0.80 m-kg	65.5 in 1.66 m	255.5 in-lb 2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

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